

Process Sheet *split*

Drawing Name

: 206L1407 STEP ASSY, LH

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 43489A - 2
 Estimate Number : 11702
 P.O. Number :
 This Issue : 17/11/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : // Type : LARGE FAB ASSY
 Previous Run : 40926A
 Written By :
 Checked & Approved By : JUL 08.11.17
 Comment : Est Rev:E As Per Ecn 766 06-01-06 JLM

Part Number : D2724041
 Drawing Number : D2724 REV C
 Project Number :
 Drawing Revision : C
 Material :
 Due Date : 02/02/2009 Shy

Qty: 4 Um: Each

*split**3*

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D2622120C	Step Extrusion 
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Qty Part # Description Batch: 1 D2622-120C Extrusion <u>47155</u>
		Check Material for any Dents or Defects
2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1 
		Comment: LARGE FABRICATION RESOURCE 1
		Cut D2724-1 using D2622 extrusion as per Dwg D2724 Deburr and bevel ends for welding
3.0	D2734	Step End Plate 
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s) 206 Step Endplate Pick: Qty Part Number Description Batch 2 D2734 End Cap <u>339179</u>
4.0	D34581	Step Mounting Plate 
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s) Pick: Qty Part Number Description Batch 2 D3458-1 Plate <u>343025=1</u> <u>844002=1</u>

Date:
User:

Monday, 17/11/2008 1:53:12 PM
Julie Dawson

Customer: CU-DAR001 Dart Helicopters Services

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Seq. #:	Machine Or Operation:	Description :
5.0	D34583	Step Mounting Plate
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)	
	Pick: Qty Part Number Description Batch 2 D3458-3 Plate 343086=4 344003=2 11/08-12/2004	
6.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
	Comment: LARGE FABRICATION RESOURCE 1	
	Weld end cap and lugs as per Dwg D2724 using Jig DT8884 followed by Jig DT (One End Only) A/R AL ROD Batch: 11/05/03 11/05/06	11/09/05 4
	Grind end cap welds flush	11/09/05 4
7.0	QC9	VISUAL WELDING INSPECTION
	Comment: VISUAL WELDING INSPECTION	11/09/06 4
8.0	QC5	INSPECT WORK TO CURRENT STEP
	Comment: INSPECT WORK TO CURRENT STEP	11/09/06 4 LH
9.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
	Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1	11/09/06 4
10.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
	Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION	11/09/06 4
11.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
	Comment: LARGE FABRICATION RESOURCE 1	
	Inspect for foreign object per QSI 024	11/09/09 4

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Seq. #:	Machine Or Operation:	Description :
	Weld Remaining end cap as per Dwg D2724 using Jig DT DT A/R AL ROD Batch: M108037	followed by Jig PL 09.01.09 4 PL 09.01.09 4
	Grind per dwg D2724	
12.0	QC9	VISUAL WELDING INSPECTION Comment: VISUAL WELDING INSPECTION ZT 09.01.09 4
13.0	QC5	INSPECT WORK TO CURRENT STEP Comment: INSPECT WORK TO CURRENT STEP S 09.01.09 44 CH
14.0	HAND FINISHING1	HAND FINISHING RESOURCE #1 Comment: HAND FINISHING RESOURCE #1 4X
15.0	SPRAY PAINTING	SPRAY PAINTING Comment: -PRIME -GREY B 110199 -SPRAY PAINT DELFLEET BLUE B 110077 -CLEAR DELFLEET B 110161 RT 09-01-12
16.0	QC14	INSPECT SPRAY PAINT m 09.01.13 C
17.0	HAND FINISHING1	HAND FINISHING RESOURCE #1 M10454
18.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION Comment: Wing Walk as per Dwg D2724 and QSI 00 54.4 A.M 09.01.16 ④
		Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION MS 09-01-19 X3

Date: Monday, 17/11/2008 1:53:12 PM

User: Julie Dawson

Process Sheet

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Job Number: 43489A

Part Number: D2724041

Job Number:



Seq. #: Machine Or Operation:

Description :

19.0 PACKAGING 1

PACKAGING RESOURCE #1



32

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

43489

glb8

Sel

20.0 QC21

FINAL INSPECTION/W/O RELEASE



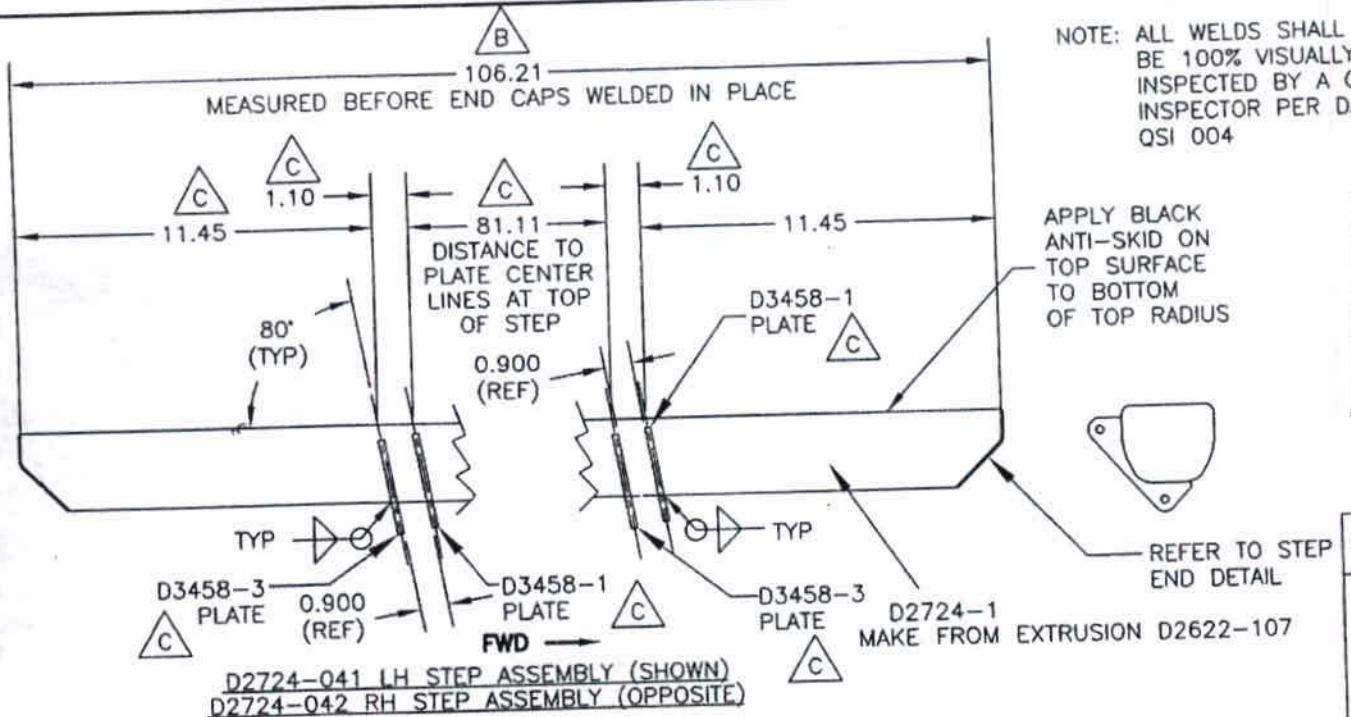
09/02/02

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-01-29



D2721-041/-042 STEP ASSEMBLY PARTS LIST

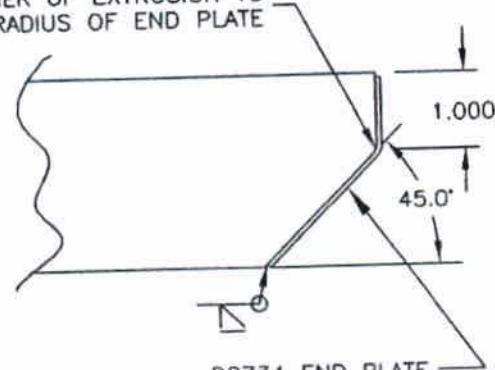
QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X	X	D2724-041	LH STEP ASSEMBLY
		D2724-042	RH STEP ASSEMBLY
1	1	D2622-107	EXTRUSION
2	2	D2734	END PLATE
2	2	D3458-1	PLATE
2	2	D3458-3	PLATE

D2724-041/-042 STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
NOTICE
NO. 43789A

ROUND CORNER OF EXTRUSION TO
MATCH BEND RADIUS OF END PLATE



TYPICAL STEP END DETAIL
NOT TO SCALE

DESIGN K.E	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED <i>W</i>	APPROVED <i>W</i>	DRAWING NO. D2724
DATE 05.09.19	97.12.04	TITLE 206L/407 STEP ASSEMBLY
A	98.10.19	REV. C SHEET 1 OF 1 SCALE N/A
B	05.09.19	UPDATED WELD DETAIL REVISED TOLERANCES
C		RE-DESIGN, ADD D3458-1/-3